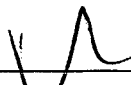
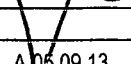


Rush!

Dart Aerospace Ltd.

Date: Thursday, 25/01/2007 11:25:07 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 30306		
Estimate Number	: 10774		
P.O. Number	: N/A	Part Number	: D3414041
This Issue	: 25/01/2007 S.O. No. : N/A	Drawing Number	: D3414 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 30306	Material	: N/A
Written By	: 	Due Date	: 01/02/2007 Qty: 20 Um: Each
Checked & Approved By	: 		
Comment	: Est A 05.09.13 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S12GA	304/316 .100" Sheet
-----	-----------	---------------------



Comment: Qty.: 0.1523 sf(s)/Unit Total: 3.0450 sf(s)

304/316 stainless steel 0.100" Sheet

Batch: *m103033X ml 07 02 13* (20)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



✓ Comment: FLOW WATER JET

1-Cut as per Dwg D3414

Dwg Rev: *A* *ml 07 02 13* (20)Prog Rev: *A*2-Deburr if necessary *SB 07/02/14* (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE *ml 07 02 13* (20)

4.0	QC8	SECOND CHECK
-----	-----	--------------

Comment: SECOND CHECK *07 02 14* (20)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr

Form using DT8254 as per Dwg D3414 *SB 07/02/14* (20)

Date: Thursday, 25/01/2007 11:25:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 30306

Part Number: D3414041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

M 07/12/14 (20)

7.0	D34143	Lug
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Lug

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3414-3	Lug	B24601
---	---------	-----	--------

A/R SS Rod

M 18 712

FC 07 02 14 (20)

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

M/FC 07 02 14 (20)

9.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

PD 07-02-22 (20)

10.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

PD 07-22-22 (20)

11.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 103 141

M-R / YR

07/02/26

(20x)

12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 7/12/27 (20)

13.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PD 7/12/27 (20)

Date: Thursday, 25/01/2007 11:25:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 30306

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

207/02/27

Job Completion



U 17-02-27

Date: Tuesday, 1/16/2007 11:37:15 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LUG ASSEMBLY
Job Number :	30306		
Estimate Number :	10774		
P.O. Number :		Part Number :	D3414041
This Issue :	1/16/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3414 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	24609	Drawing Revision :	A
		Material :	
Written By :		Due Date :	1/30/2007
Checked & Approved By :		Qty:	20
Comment :	Est A 05.09.13 New issue KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: _____
 Email or Ship DXF file to vendor
 Laser Cut flat pattern per Dwg D3414
 Possible Supplier: Industrial Laser
 Material release note is required

W. H. H. H.

2.0	D34141	Lug Bracket
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 LUG ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per template D2658T1 & Dwg D3414

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

Deburr
 Form using DT8254 as per Dwg D3414

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:37:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 30306

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

D34143

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Lug

Pick:

Qty Part Number Description Batch

1 D3414-3 Lug

A/R SS Rod

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:37:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 30306

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

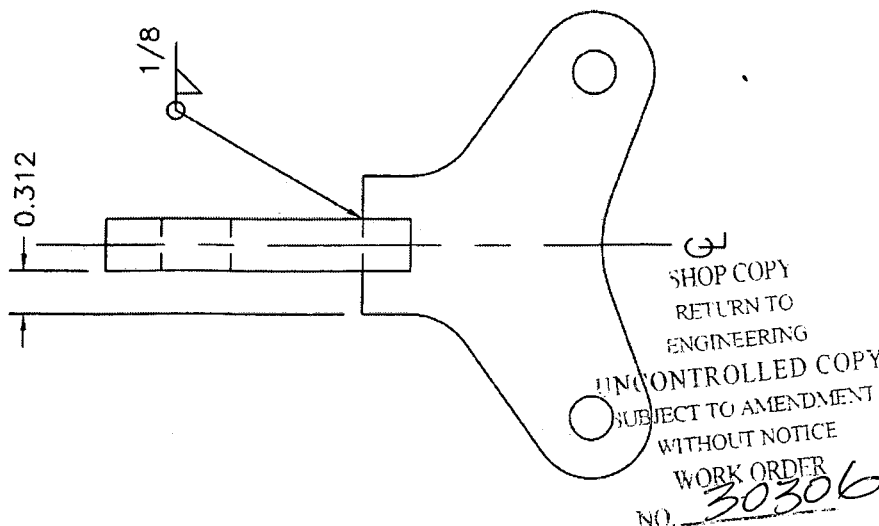
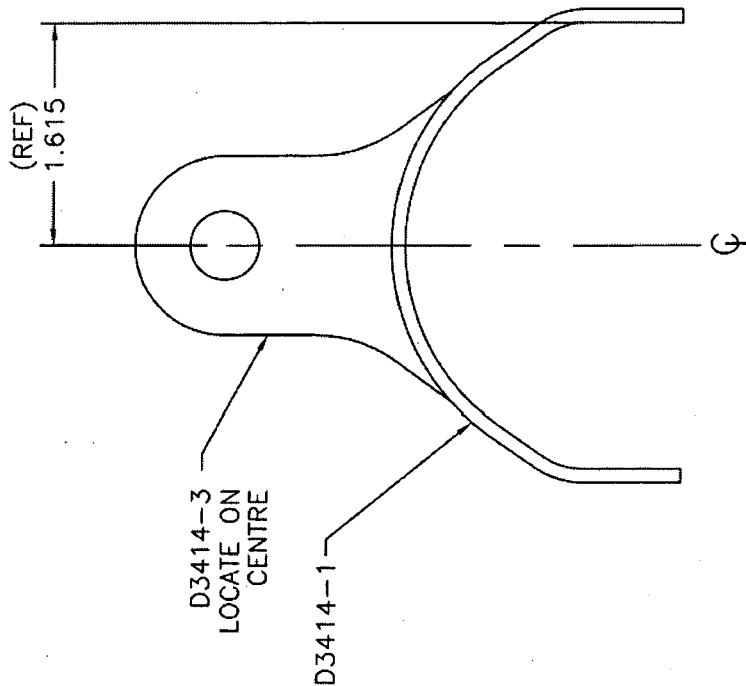
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 1 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE NTS
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 *[Signature]*



D3414-041 LUG ASSEMBLY

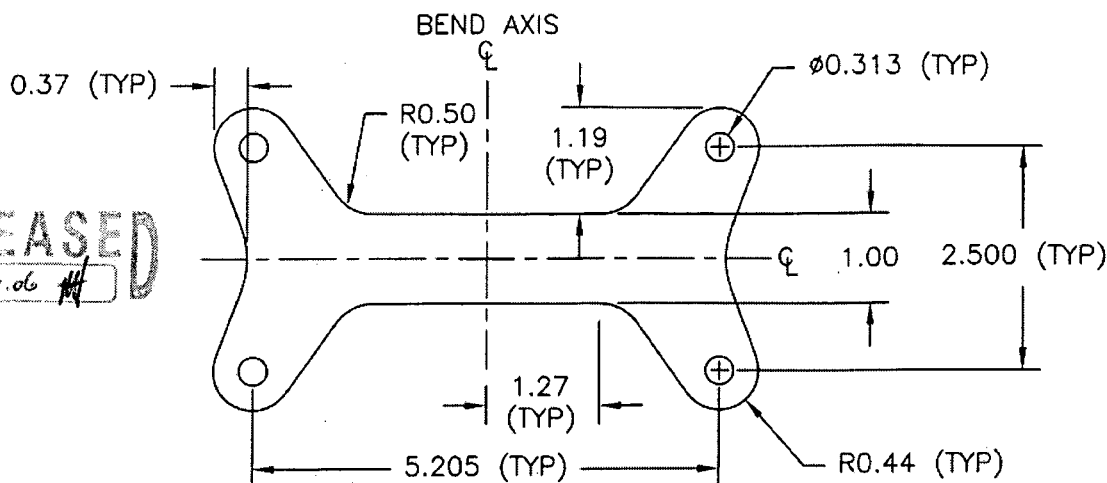
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

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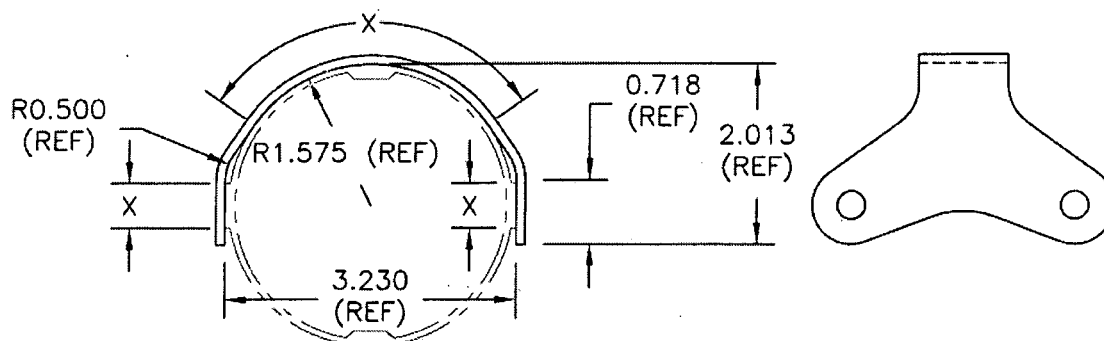
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2

RELEASED
05.09.06 *[Signature]***D3414-1 FLAT PATTERN**

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)

**D3414-1 BEND DETAIL**

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 30306

D3414-1 LUG BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

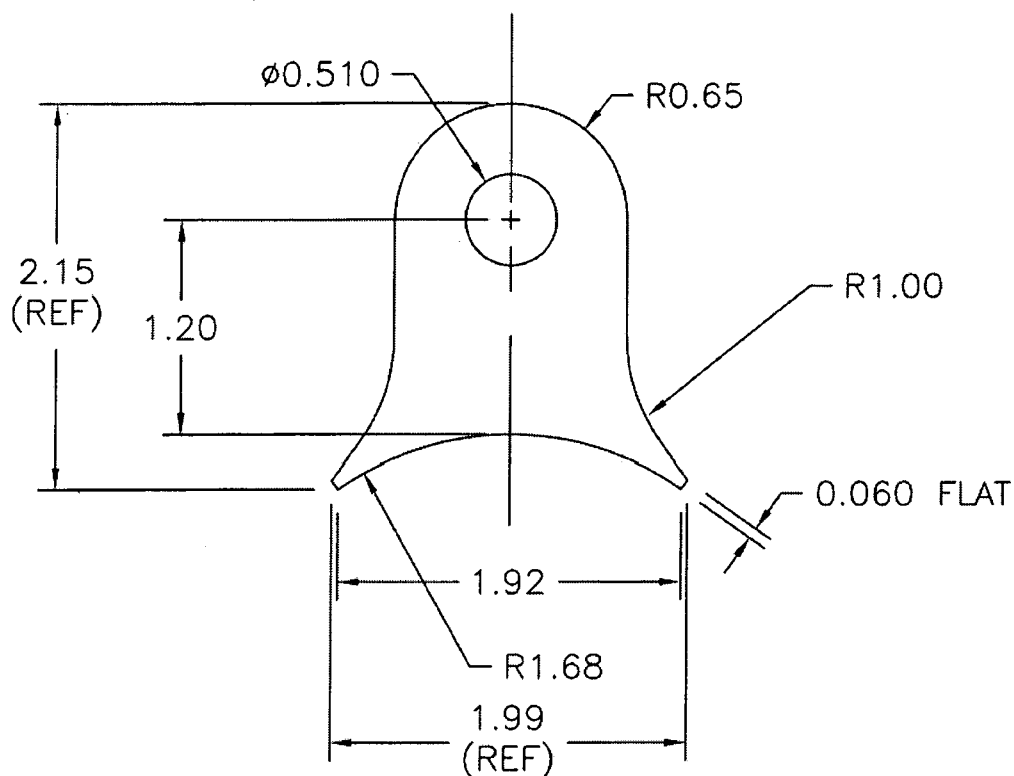
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 3 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1

RELEASED
05-07-06 *[Signature]*

**D3414-3 LUG**

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

STOP COPY
RETURN TO
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NO. **30306**

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FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by: <i>mm</i>	Audited by:	Prototype Approval:
Date: <i>070213</i>	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	